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D350-591-312
Job Sheet 166570



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/11/17

Job Tracking No:

Due Date: 10/20/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Airbus Helicopters - Marignane (CEURO24)

Aéroport International De Marseille Cedex Marignane Marseille, , 13725 France ph:+33 4 42 85 85 85 fx:+33 4 42 85 83 00.

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	10 Ea	10/18/17	0.00	0.00	Start up container	
100	DC	10 pcs	10/18/17	0.00	0.00	DC	
110	Large Fab	10 pcs	10/19/17	0.00	10.00	Large Fab 2	SL DAS 10/30/17
120	QC	10 pcs	10/19/17	0.00	0.00	QC9	9 DAS
130	QC	10 pcs	10/19/17	0.00	0.00	QC5	9-80 9
140	HandFinish	10 pcs	10/19/17	0.00	1.87	HandFinish1	2017/11/13 9-80
150	QC	10 pcs	10/19/17	0.00	0.00	QC7	38
180	Large Fab	10 pcs	10/19/17	0.00	10.00	Large Fab 2	9-80 CC 17-11-2
190	QC	10 pcs	10/19/17	0.00	0.00	QC10	17-11-2
200	QC	10 pcs	10/19/17	0.00	0.00	QC5	17-11-2
210	HandFinish	10 pcs	10/19/17	0.00	1.87	HandFinish1	JSL 2017-11-03
220	Powdercoat	10 pcs	10/19/17	0.00	2.98	Powdercoat1	BR 17-11-6
230	HandFinish	10 pcs	10/20/17	0.00	1.87	HandFinish3	17-11-10 38
240	QC	10 pcs	10/20/17	0.00	0.00	QC3	9-80
250	Packaging	10 pcs	10/20/17	0.00	0.00	Packaging1	
260	QC	10 pcs	10/20/17	0.00	0.00	QC4	7-10
270	Packaging	10 pcs	10/20/17	0.00	0.00	Packaging3	SmB
280	QC21-FG	10 Ea	10/20/17	0.00	0.00	QC21	17/11/20

Part Op 100 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Descriptions: 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg D3272

180 - 1-Assemble Leg Assembly as per Dwg D3272.

220 - START TIME: 18:00 O.V.T 8:20 FINISH 18:30

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D3067-1 166077	10	79	0	0
	D3219-1 166284-2	20	153	0	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

80-Large Fat

250-Packaging

D3272-1	162484	10	3	0	0
D3065-041		10	48	0	0
D3066-1		20	66	0	0
D3067-1		10	79	0	0
MS20600-AD4W4	FM 138441	160	626	0	0
AN3-35A	FM 138170	20	22	0	0
AN4-13A	5007369	80	20	0	0
AN5-36A	5007366	20	4	0	0
D2230-3	5007390	40	132	0	0
D2618	5007401	20	17	0	0
D2856-400	5007401	12	283	0	0
D3235-1	16275711	20	13	0	0
D3278-041	5007375	10	27	0	0
MS21042L3	5007366	20	462	0	0
MS21042L4	5007335	80	1,089	0	0
MS21042L5	5007208	20	109	0	0
NAS1149D0363J	5007197	40	955	0	0
NAS1149D0463J	5007190	160	1,118	0	0
NAS1149D0563J	500718	40	846	0	0

5009393

Part Specifications

Specifications could not be found.

Plex 10/11/17 2:44 PM Dart.lajeunesse.marie

D3065-041

-B165204 → 6

-B165610 → 3

B164383 → 1-5004891

D3067-1

F166077 → 22

F165725 → 18

D3066-1

F162500 → 6

F165744 → 14

Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X						D350-591-213	<i>Hel-Access-Step™</i> , Short Step – High Skid, LH
	X					D350-591-214	<i>Hel-Access-Step™</i> , Short Step – High Skid, RH
		X				D350-591-215	<i>Hel-Access-Step™</i> , Short Step – Low Skid, LH
			X			D350-591-216	<i>Hel-Access-Step™</i> , Short Step – Low Skid, RH
				X		D350-591-311	<i>Hel-Access-Step™</i> , Long Step – High Skid, LH
					X	D350-591-312	<i>Hel-Access-Step™</i> , Long Step – High Skid, RH
1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
				1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
					1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
2	2	2	2	4	4	D2230-3	MOUNTING LUG
2	2	2	2	2	2	D2618	BUSHING
4	4	4	4			D2732-030	CUSHION
				2	2	D2856-400-720	ABRASION STRIP
2	2	2	2	2	2	D3235-1	MOUNTING LUG
				1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	AN3-35A	BOLT
				8	8	AN4-13A	BOLT
4	4	4	4			AN4-15A	BOLT
2	2	2	2	2	2	AN5-36A	BOLT
4	4	4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
12	12	12	12	16	16	NAS1149D0463J	WASHER (AN960JD416)
4	4	4	4	4	4	NAS1149D0563J	WASHER (AN960JD516)
2	2	2	2	2	2	MS21042L3	NUT
6	6	6	6	8	8	MS21042L4	NUT
2	2	2	2	2	2	MS21042L5	NUT
				1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 15 for installation of the DSI 9410-011 Kit.